

Work Order ID 86777

86777

Page 1

July-06-12 2:44:51 PM

Item ID: D3112-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Guide
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3112	Rev B								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 *cut 12/10/19* 6 0
 Jeaspa Bandsaw Cut blanks: 0.625" x 1.500 bar x 2.625" long.

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS I Memo 0.00 *B.A 12/10/20* 6 0
 HAAS CNC vertical machine #1 Machine as per Folio FA233Note: Engrave / scribe DART P/N on part as per
 dwg. Deburr break all unmarked sharp edges .005 to 0.010

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 *B.A 12/10/20* 6 0
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86777

86777

Page 2

July-06-12 2:44:51 PM

Item ID: D3112-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Guide
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

W 122966 3200 F 11:40 12:10

6X10 m/f 12/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86777


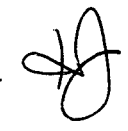
86777

Page 3

July-06-12 2:44:51 PM

Item ID: D3112-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Guide
Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 8/03/12 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						6	0	12-10-23	
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>ST026</u>	0.00							
170						6		12/10/23/B	
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180								12/10/24	
QC	Memo	0.00							
Quality Control									

12-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 2:44:51 PM

Page 1

Work Order ID: 86777

Parent Item: D3112-1

Parent Item Name: Guide

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A02.05.22New IssueNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.625X01.500 6061-T6 Bar .625 x 1.50		Purchased	No			100	f	10.8000	0.2271	1.4343156			

Location

Loc Qty

Loc Code

MAT002

10.8

115111

10.8

M123279 x1.44 on 12/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>PL 777</i>
Description: Guide		Part Number:	D3112-1
Inspection Dwg: D3112	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓		Vern	GA-01
0.500	+/-0.010	0.504	✓		"	"
R0.063	+/-0.010	R0.063	✓		R-6	ref.
0.125	+/-0.010	0.125	✓		Vern	GA-01
0.500	+/-0.010	0.500	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
0.155	+/-0.010	0.155	✓		"	"
1.005	+/-0.010	1.005	✓		"	"
0.412	+/-0.010	0.412	✓		"	"
0.191	+/-0.010	0.190	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
2.500	+/-0.010	2.500	✓		"	"
Ø0.191	+0.005/-0.000	Ø0.192	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-6	ref.

Measured by:	<i>B-n</i>	Audited by:	<i>RP</i>	Prototype Approval:	N/A
Date:	<i>12/10/20</i>	Date:	<i>2.10.21</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.07.07	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

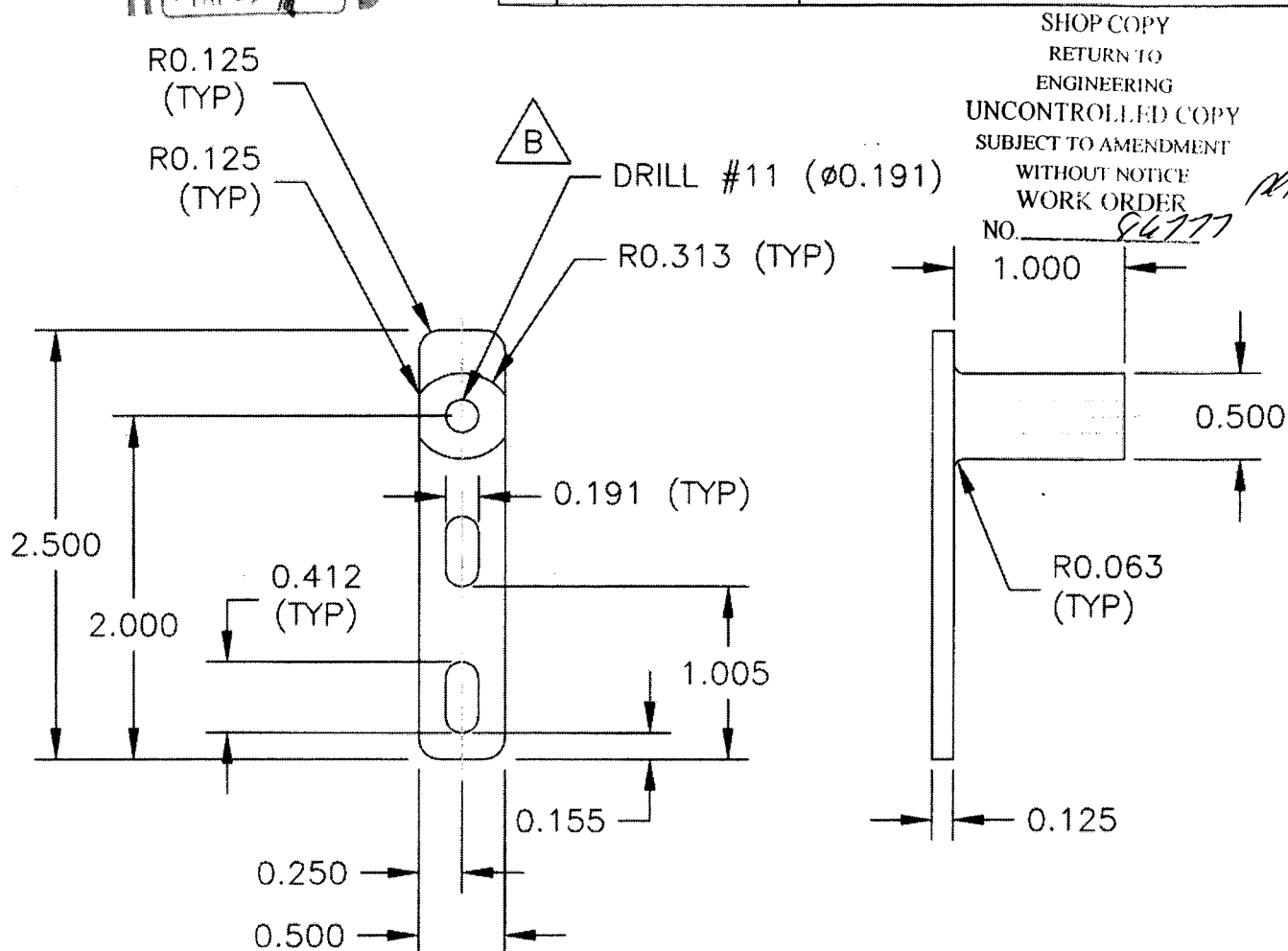
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; Ø0.191 WAS Ø0.185	

RELEASED
04.11.23



D3112-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries